

Date: Thursday, 07/08/2008 12:58:44 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D412-742-013  
 Job Number : 41046  
 Estimate Number : 10804  
 P.O. Number :  
 This Issue : 07/08/2008 S.O. No. :  
 Prsh't Rev. : NC  
 First Issue : / / Type : LANDING GEAR  
 Previous Run : 30473  
 Written By :  
 Checked & Approved By :  
 Comment :

Part Number : D412742013  
 Drawing Number : DSI 9369/ECN08-510  
 Project Number :  
 Drawing Revision :  
 Material :  
 Due Date : 14/08/2008 Qty: 1 Um: Each

## Additional Product

Job Number:



<b>DART</b>		TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89			
PN	D412-742-013	CHG	CHG004
DFSC	Float Skidtube	SIC	SR01583SE
LOT	B35742	SIC	SH05-37
MODEL	205/210/212/412/AB412	SIC	
US PATENT # 5735384 CANADA FOREIGN PATENTS PENDING			
MADE IN CANADA			

Seq. #:

Machine Or Operation:

Description:

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE FROM STK:

D412-742-013 B 35742

2.0

D412742013

Float Skidtube Installation



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Float Skidtube Instln

3.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

REMOVE END CAPS BOTH ENDS  
 TO REMOVE/CLEAN LPS FROM TUBE

FOWARD TUBE TO SKIDTUBE CELL

FL 06/08/07

4.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

A) - DRILL 0.500 DIAM. HOLES THRU D3391-021 FWD TUBE AND D3391-023 MID TUBE(2 PLACES) AS SHOWN ON DSI 9364.

INSTALL D3591-1 BUSHING B 31514

B) - DEBURR ALL HOLES

- TOUCH UP ALODINE

- TOUCH UP PAINT

C) - RECOAT WITH LPS3 B M107912

DP 88-8 88-8  
 JH 08-08-26

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D412-742-013 PAR #: NA Fault Category: Prod / Skidube NCR: Yes No DQA: D Date: 08/08/27  
 QA: N/C Closed: D Date: 08/08/27

NCR: <u>41046</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-08-13	4.0	The most fuel hole had been opened. Incorrect hole. R.C: Human error.	<u>[Signature]</u>	Scrap: replace the mid-tube. Qty 1 <u>B-40522</u> <u>[Signature]</u>	<u>[Signature]</u> 08/08/27	<u>[Signature]</u> 08/08/27	<u>[Signature]</u>	<u>[Signature]</u> 08-08-13

NOTE: Date & initial all entries

Date: Thursday, 07/08/2008 12:58:44 PM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-742-013

Job Number: 41046

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35911

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
BUSHING

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
REINSPECT KIT FOR 100% COMPLETENESS

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
REPACKAGE PER PPP USING NEW B/N.  
NEW PAPERWORK & LABELS REQ'D  
CHG 005  
-ENSURE DSI PAPERWORK ADDED

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-28

B41046


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DESIGN PH	DRAWN BY AJS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED	DRAWING NO. DSI 9364	REV. C SHEET 1 OF 1
DATE 08.08.06	TITLE BUSHING INSTALLATION		SCALE NTS
A	07.01.16	NEW ISSUE	
B	07.03.20	ADD TOLERANCE TO 1/2" HOLE	
C	08.08.06	ADDED CHG 005 & SUBS TO EFFECTIVITY. TOLERANCE ON 1/2" HOLES WAS +0.006 -0.000	

REFERENCE ONLY

## DART SERVICE INSTRUCTION

TO AMEND IIN-D412-742 REV. B AND ICA-D412-742 REV. 1  
REF. FAA STC: SR01583SE  
REF. CANADIAN STC: SH05-37 ISSUE 1

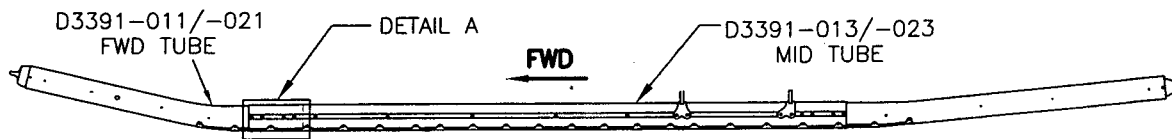
TO PREVENT THE D3391-011/-021 FWD TUBE FROM MOVING WITH RESPECT TO THE D3391-013/-023 MID TUBE, CUSTOMERS RECEIVING D412-742-011/-013 SKIDTUBES AT CHG 002 OR CHG 005 AND SUBSEQUENTS HAVE A D3591-1 BUSHING INSTALLED AT THE FWD SADDLE HOLES AS SHOWN IN DETAIL A (2 PLACES).

CUSTOMERS WITH D412-742-011/-013 SKIDTUBES AT CHG 001, CHG 003 AND CHG 004 CAN PROCURE THE DSI 9364-011 KIT AND INSTALL THE D3591-1 BUSHINGS AS FOLLOWS:

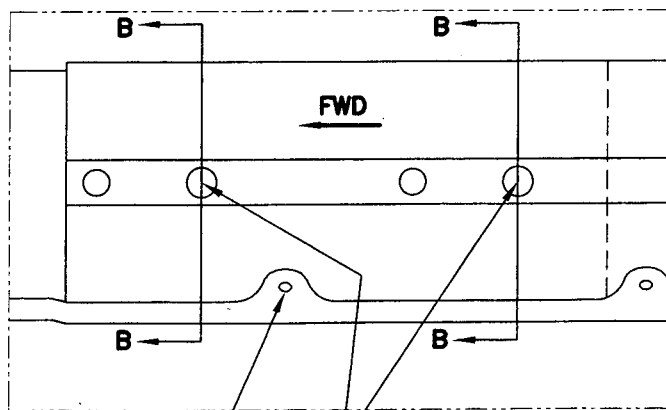
- 1) REMOVE SKIDTUBE/SADDLES FROM AIRCRAFT USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE.
- 2) TRANSFER DRILL 1/2" HOLES ( $\varnothing 0.500 \pm \begin{smallmatrix} 0.002 \\ 0.000 \end{smallmatrix}$ ) INTO THE FWD SADDLE HOLES AT THE LOCATIONS SHOWN (2 PLACES) THRU THE D3391-013/-023 MID TUBE AND D3391-011/-021 FWD TUBE. **DO NOT OPEN UP HOLES IN D2571/D2572 FWD SADDLES.**
- 3) REMOVE FWD TUBE FROM MID TUBE, DEBURR DRILLED HOLES, TOUCH UP HOLES WITH MIL-P-85582 OR MIL-P-23377 PRIMER
- 4) RE-INSTALL D3391-011/-021 FWD TUBE INTO D3391-013/-023 MID TUBE USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE EXCEPT INSTALL D3591-1 BUSHINGS AS SHOWN IN DETAIL A USING LPS LABORATORIES LPS-3 CORROSION INHIBITOR PRIOR TO INSTALLING THE D2571/D2572 SADDLES.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9364-011	BUSHING INSTALLATION
2	D3591-1	BUSHING

REFERENCE ONLY



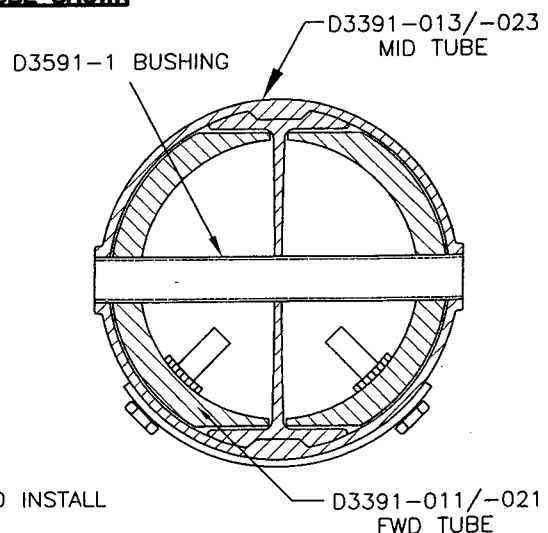
D412-742-011/-013 SKIDTUBE SHOWN



ENSURE BOLT IS FASTENED  
PRIOR TO TRANSFER DRILLING  
(REF)

OPEN TO  $\varnothing 0.500 \pm \begin{smallmatrix} 0.006 \\ 0.000 \end{smallmatrix}$  AND INSTALL  
D3591-1 BUSHING  
(2 PLACES)

DETAIL A: D3591-1 BUSHING INSTALLATION LOCATION



SECTION B-B

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

REFERENCE ONLY

DESIGN PH	DRAWN BY AJS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. DSI 9364	REV. C SHEET 1 OF 1
DATE 08.08.06		TITLE BUSHING INSTALLATION	SCALE NTS
A	07.01.16	NEW ISSUE	
B	07.03.20	ADD TOLERANCE TO 1/2" HOLE	
C	08.08.06	ADDED CHG 005 & SUBS TO EFFECTIVITY	

REFERENCE ONLY

## DART SERVICE INSTRUCTION

TO AMEND IIN-D412-742 REV. D AND ICA-D412-742 REV. 3

REF. FAA STC: SR01583SE

REF. CANADIAN STC: SH05-37 ISSUE 1

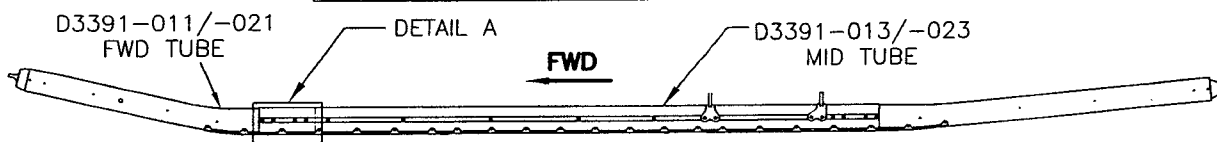
REF EASA STC: IM.R.S.01126

TO PREVENT THE D3391-011/-021 FWD TUBE FROM MOVING WITH RESPECT TO THE D3391-013/-023 MID TUBE, CUSTOMERS RECEIVING D412-742-011/-013 SKIDTUBES AT CHG 002 OR CHG 005 AND SUBSEQUENTS HAVE A D3591-1 BUSHING INSTALLED AT THE FWD SADDLE HOLES AS SHOWN IN DETAIL A (2 PLACES).

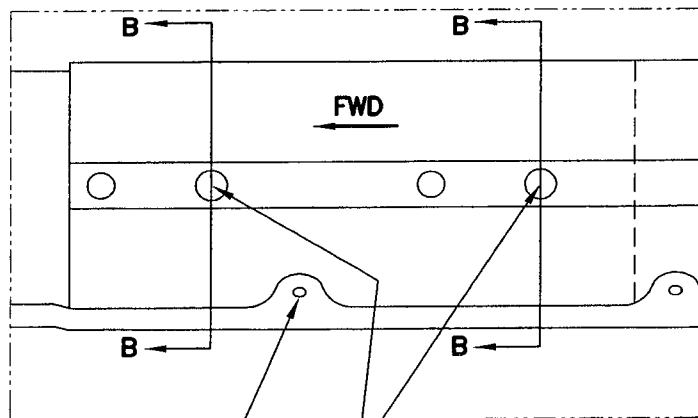
CUSTOMERS WITH D412-742-011/-013 SKIDTUBES AT CHG 001, CHG 003 AND CHG 004 CAN PROCURE THE DSI 9364-011 KIT AND INSTALL THE D3591-1 BUSHINGS AS FOLLOWS:

- 1) REMOVE SKIDTUBE/SADDLES FROM AIRCRAFT USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE.
- 2) TRANSFER DRILL 1/2" HOLES ( $\varnothing 0.500 \pm \begin{smallmatrix} 0.006 \\ 0.000 \end{smallmatrix}$ ) INTO THE FWD SADDLE HOLES AT THE LOCATIONS SHOWN (2 PLACES) THRU THE D3391-013/-023 MID TUBE AND D3391-011/-021 FWD TUBE. DO NOT OPEN UP HOLES IN D2571/D2572 FWD SADDLES.
- 3) REMOVE FWD TUBE FROM MID TUBE, DEBURR DRILLED HOLES, TOUCH UP HOLES WITH MIL-P-85582 OR MIL-P-23377 PRIMER
- 4) RE-INSTALL D3391-011/-021 FWD TUBE INTO D3391-013/-023 MID TUBE USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE EXCEPT INSTALL D3591-1 BUSHINGS AS SHOWN IN DETAIL A USING LPS LABORATORIES LPS-3 CORROSION INHIBITOR PRIOR TO INSTALLING THE D2571/D2572 SADDLES.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9364-011	BUSHING INSTALLATION
2	D3591-1	BUSHING



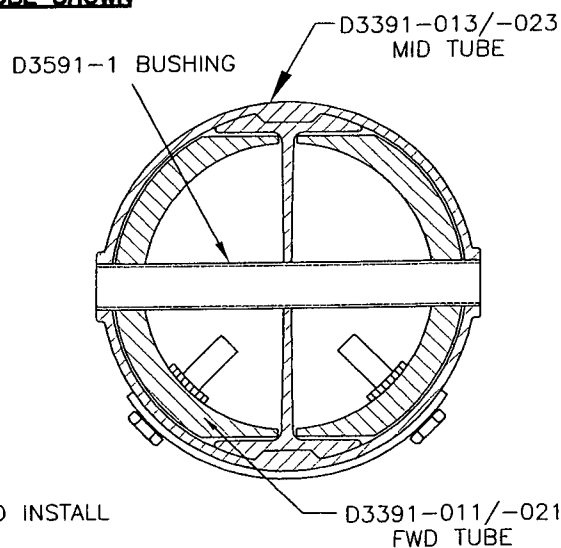
**D412-742-011/-013 SKIDTUBE SHOWN**



ENSURE BOLT IS FASTENED PRIOR TO TRANSFER DRILLING (REF)

OPEN TO  $\varnothing 0.500 \pm \begin{smallmatrix} 0.006 \\ 0.000 \end{smallmatrix}$  AND INSTALL D3591-1 BUSHING (2 PLACES)

**DETAIL A: D3591-1 BUSHING INSTALLATION LOCATION**



**SECTION B-B**

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Date: Friday, 15/08/2008 9:19:00 AM  
 User: Linda Lacelle

**JOB HISTORY : DETAIL**

<b>Job Number</b>	: 35742A	<b>Customer</b>	: Dart Helicopters Services
<b>Estimate Number</b>	: 10756	<b>DWG Name</b>	: FLOAT SKID ASSEMBLY
<b>Purchase Order #</b>	:	<b>Part Number</b>	: D412742043
<b>Complete Date</b>	: 31/01/2008 11:59:59	<b>DWG Number</b>	: D3391 REV G
		<b>Rev.</b>	: D

DUE DATE	ORDERED	DELIVERED
30/12/2007	1	1

**2.0 HAND FINISHING1 Internal Operation**

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
02/01/2008	LAUG01: Laughren, Gary	Run	1.000	5.20	\$69.78	5.20	135.37
03/01/2008	LAUG01: Laughren, Gary	Run	0.000	0.97	\$13.02	0.97	25.26
04/01/2008	LAUG01: Laughren, Gary	Run	0.000	0.27	\$3.62	0.27	7.02
<b>Subtotal:</b>			QTD:	1 CTD:	0	6.44	\$254.07

**3.0 D3391023-Mid Tube Assembly INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty	COST
01/02/2008	LACE01: Lacelle, Linda	D3391023	1.000	\$358.60
				Lot # 33637 Qty. 1
<b>Subtotal:</b>			QTD:	1 CTD:
			0	\$358.60

**4.0 D3391025-Aft Tube Assembly INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty	COST
01/02/2008	LACE01: Lacelle, Linda	D3391025	1.000	\$950.44
				Lot # 35772 Qty. 1
<b>Subtotal:</b>			QTD:	1 CTD:
			0	\$950.44

**5.0 D35641-Wearshoe INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty	COST
02/01/2008	LAUG01: Laughren, Gary	D35641	1.000	\$51.73
				Lot # 33243 Qty. 1
<b>Subtotal:</b>			QTD:	0 CTD:
			1	\$51.73

bott # 1340988

**6.0 D35661-Gasket INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty	COST
02/01/2008	LAUG01: Laughren, Gary	D35661	2.000	\$3.25
				Lot # 36339 Qty. 2
<b>Subtotal:</b>			QTD:	0 CTD:
			2	\$3.25

**7.0 D35643-Wearshoe INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty	COST
02/01/2008	LAUG01: Laughren, Gary	D35643	1.000	\$85.45
				Lot # 34052 Qty. 1
<b>Subtotal:</b>			QTD:	0 CTD:
			1	\$85.45

**8.0 D35645-Wearshoe INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty	COST
02/01/2008	LAUG01: Laughren, Gary	D35645	1.000	\$21.40
				Lot # 36111 Qty. 1
<b>Subtotal:</b>			QTD:	0 CTD:
			1	\$21.40

**10.0 AN3C4A-BOLT INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty	COST
02/01/2008	LAUG01: Laughren, Gary	AN3C4A	24.000	\$7.20
				Lot # 106277 Qty. 24
<b>Subtotal:</b>			QTD:	0 CTD:
			24	\$7.20



Date: Friday, 15/08/2008 9:19:00 AM

User: Linda Lacelle

**JOB HISTORY : DETAIL**

<b>Job Number</b>	: 35742A	<b>Customer</b>	: Dart Helicopters Services
<b>Estimate Number</b>	: 10756	<b>DWG Name</b>	: FLOAT SKID ASSEMBLY
<b>Purchase Order #</b>	:	<b>Part Number</b>	: D412742043
<b>Complete Date</b>	: 31/01/2008 11:59:59	<b>DWG Number</b>	: D3391 REV G
		<b>Rev.</b>	: D

**11.0 AN3C6A-BOLT INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty	COST	
02/01/2008	LAUG01: Laughren, Gary	AN3C6A	12.000	\$5.24	Lot # 105057 Qty. 12

**Subtotal:** QTD: 0 CTD: 12 \$5.24

**12.0 AN3C7A-BOLT INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty	COST	
02/01/2008	LAUG01: Laughren, Gary	AN3C7A	8.000	\$3.33	Lot # 105906 Qty. 8

**Subtotal:** QTD: 0 CTD: 8 \$3.33

**13.0 AN960C10L-washer INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty	COST	
01/02/2008	LACE01: Lacelle, Linda	AN960C10L	44.000	\$2.63	Lot # 106574 Qty. 44

**Subtotal:** QTD: 44 CTD: 0 \$2.63

		TIME	COST	
	Machine Time:	6.44	\$167.65	
	Labor:	6.44	\$86.42	
	Sub-contract (external Op.):		\$0.00	
	INVENTORY ITEM:		\$1489.27	
	SUB-COMPONENT (SUB-JOB):		\$0.00	
<b>Total:</b>			\$1743.34	

COST PER UNIT: \$1743.34

Date: Thursday, 07/08/2008 1:03:23 PM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-742-013

Job Number: 41046

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35911

Bushing

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
REINSPECT KIT FOR 100% COMPLETENESS

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
REPACKAGE PER PPP USING NEW B/N.  
NEW PAPERWORK & LABELS REQ'D  
CHG 005  
-ENSURE DSI PAPERWORK ADDED

JW 08.8.13

DSI 9369

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



REFERENCE ONLY